



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Stock

647.3914
Job Sheet 190365



Part No: 647.3914

Job Qty: 6 pcs

Part Name: Breakaway Tip, Long



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/19

Job Tracking No:

Due Date: 2/28/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *March 15*

Description:

Note: DWG REV C2 SHEETS 1,4,9 IPP REV. A NEW ISSUE JFS 14/06/19 VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	2/28/19	2/28/19	0.00	4.91	Bandsaw - 1	DAS	<i>19/02/16</i>
110	HAAS 4 Axis - B4B	6 pcs	2/28/19	2/28/19	0.19	4.91	HAAS - 1 - B4B	52	<i>19/02/16</i>
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs	2/28/19	2/28/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	DAS	
							QC 2 - 52	52	
							QC 2 - 54	9-89	
							QC 2 - 56		
							QC 2 - 57		



Container No: S156442



Part: 647.3914

Job No: 190365

Serial No/Batch: S156442

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/26/19

Plex 2/7/19 1:45 PM Dart.lajeunesse.marie

				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
130	QC 8	6 pcs	2/28/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
140	Outsource - 4 - Anodize	6 pcs	2/28/19		ATG001-VC
150	Packaging 2-1 - Receive - B4B	6 pcs	2/28/19	0.00 0.00	8
					Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B

B-A 19-02-26

C-A 19-2-27

MAR 14 2019

155 QC 6	6 pcs	2/28/19	0.00 0.00	Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 42	DAS
				QC 6 - 9	APR 02 2019 40
				QC 6 - 68	9-89
				QC 6 - 61	
180 Packaging 3-1 - Stock - B4B	6 pcs	2/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	CK002
				Packaging 3 - 28 - B4B	APR 02 2019
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	6 pcs	2/28/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-88

Part Op 100 - (Bandsaw) Cut Blank at 14.500"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB315

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : _____

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S2.000X0.750	7075-T6S Sheet 2" Thick Plate X 0.75" Wide	7.2540 ft (1.209 ea)	100-Bandsaw - 1	5156420

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S2.000X0.750	7	7	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Breakaway Tip Long	0.189inches + 0.005 - 0.001	0.194 0.188	0.189	diameter
2	Breakaway Tip Long	0.194inches + 0.005 - 0.001	0.199 0.193	0.194	diameter
3	Breakaway Tip Long	8.611inches ± 0.005	8.616 8.606	8.613	
4	Breakaway Tip Long	7.876inches ± 0.005	7.881 7.871	7.876	
5	Breakaway Tip Long	1.224inches ± 0.005	1.229 1.219	1.224	
6	Breakaway Tip Long	0.252inches ± 0.005	0.257 0.247	0.252	
7	Breakaway Tip Long	42.830degrees ± 0.500	43.330 42.330	42.8	angle
8	Breakaway Tip Long	37.100degrees ± 0.500	37.600 36.600	37.1	angle
9	Breakaway Tip Long	0.533inches ± 0.005	0.538 0.528	0.533	
10	Breakaway Tip Long	0.560inches ± 0.005	0.565 0.555	0.558	
11	Breakaway Tip Long	0.362inches + 0.002 - 0.000	0.364 0.362	0.362	
12	Breakaway Tip Long	0.910inches ± 0.005	0.915 0.905	0.910	
13	Breakaway Tip Long	0.063inches ± 0.005	0.068 0.058	0.063	Radius
14	Breakaway Tip Long	8.618inches ± 0.005	8.623 8.613	8.620	
15	Breakaway Tip Long	0.740inches ± 0.005	0.745 0.735	0.740	
16	Breakaway Tip Long	0.306inches ± 0.005	0.311 0.301	0.306	
17	Breakaway Tip Long	2.306inches ± 0.005	2.311 2.301	2.306	
18	Breakaway Tip Long	1.556inches ± 0.005	1.561 1.551	1.556	
19	Breakaway Tip Long	0.418inches ± 0.005	0.423 0.413	0.418	
20	Breakaway Tip Long	0.175inches ± 0.005	0.180 0.170	0.175	
21	Breakaway Tip Long	45.000degrees ± 0.500	45.500 44.500	45	angle

DAS
52
J-89

19/02/26

Plex 2/7/19 1:45 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042733**



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042733

PO Date: 2/27/19

Due Date: 3/12/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lussier, PatrickPhone:

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191103	647.3915	Deflector (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 1- Black Anodize as per Dwg 647.3900	Firmed	-	3/12/19	12 pcs	0 pcs	12 pcs	\$39.54/pcs	\$474.48
2	190239	RBW6510A00436W142C-3T-3	Base Plate -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/12/19	2 pcs	0 pcs	2 pcs	\$14.54/pcs	\$29.08

3/12/2019

PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042733



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	190243	RBW6510A00436W142C-3T-7	Block -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/12/19	2 pcs	0 pcs	2 pcs	\$14.54/pcs	\$29.08
4	190365	647.3914	Breakaway Tip, Long Outsource4 (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed	-	3/12/19	6 pcs	0 pcs	6 pcs	\$16.09/pcs	\$96.54
Grand Total:											\$629.18

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/12/19 8:22 AM dart.Lussier.Patrick

DAS
40
9-89



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917439

Date: 13-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 12 ea	Part: 647.3915 ✓ Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 24710 PO: PO042733 ✓ Rev: C2 Line: 1		
✓ 6 ea	Part: 647.3914 ✓ Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 24713 PO: PO042733 ✓ Rev: C Line: 4		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>13/3/19</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

DAS
40
9-89